

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028461**Date Inspected:** 21-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site

| | | | | | | | |
|------------------------------------|---------|---------------------|-----|----------------------------------|-----|----|-----|
| CWI Name: | N/A | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | OBG | | | | |

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck panel drop-in deck splice for lift 13E. The weld was previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

Lift 13E Deck drop-in splice (Weld No. 13E-E2.2)

The QAI performed a 50% verification of this weld from Y=2425~4850. A total of one rejectable indication was observed at the time of inspection with an AWS db rating=+10 and a length of 15mm located at Y=3550. The ABF QC inspector Jesus Cayabyab was present for verification of the indication. The QAI observed Mr. Cayabyab calibrate on the QAI's IIW block present onsite. The QAI observed the ultrasonic response of the ABF QC inspectors calibrated equipment show an AWS db rating=+11. Due to the length of the Class B discontinuity being less than 20mm it was deemed to be acceptable at the time of inspection.

Magnetic Particle Testing (OBG 13E)

This QA Inspector performed a minimum of 50% verification Magnetic Particle Testing (MT) of the lift 13E longitudinal deck splice. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

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Lift 13E Deck drop-in longitudinal splice (Weld No. 13E-PP122-E2.5-BW1)

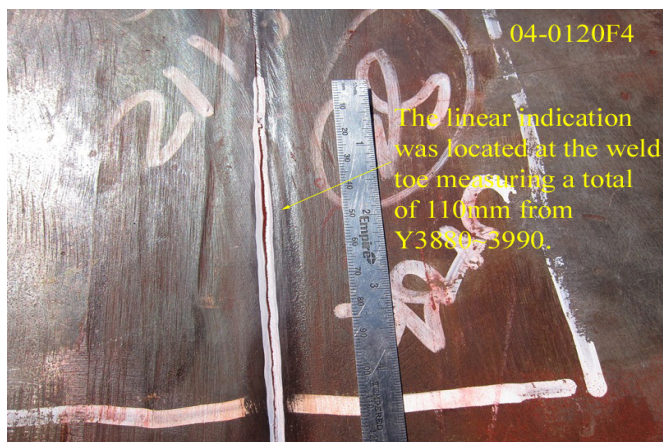
The QAI performed 50% verification of this weld from face A/B. A total of one rejectable indication was observed at the time of inspection from face A. The linear indication was located at the weld toe measuring a total of 110mm from Y3880~3990. The indication was ground to a depth of 1mm until it was no longer detectable with magnetic particle inspection. A White contrast background of the indication was used for photographic purposes only.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations relevant to the work being performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for

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your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer